

Work Order ID 71360-2

Wednesday, June 29, 2011 2:54:54 PM

Item ID: D2571

Revision ID:

Item Name: Saddle, Fwd Out 205

Start Date: 6/29/2011 Start Qty: 12.00

Required Date: 7/20/2011 Req'd Qty: 12.00

Reference:

Approvals: _____ Process Plan: _____

QC:

Date: 11-06-29 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2571

Rev E

100



HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 7136 Double check by: BP 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets. 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets. 3-Machine Step No 3 per Folio FA051 and inspect

110



Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2571 & D2572

120



Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Work Order ID 71360

Wednesday, June 29, 2011 2:54:54 PM

Page 2

Item ID: D2571

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Start Date: 6/29/2011 Start Qty: 12.00

Required Date: 7/20/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

B.A 11/07/21

6 0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

6 0 PR 11-7-21.



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

6 0 PR 11-7-21.



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:28

11:10

11:40.

Work Order ID 71360

Wednesday, June 29, 2011 2:54:54 PM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 6/29/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

169



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 433

0.00

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

6 4 11/10/12

11/7/12 SP 60

11/7/25

11-07-22
(6)

Picklist Print

Wednesday, June 29, 2011 2:55:01 PM

Page 1

Work Order ID: 71360



Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 6/29/2011

Required Date: 7/20/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 02.10.02 Re-format: Change to Dwg Rev. D & incorporated D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007

Manufactured No

100

Each

25.0000

1

12



Saddle Billet

Location

Loc Qty

Loc Code

MAT042

3

66967

3

MAT045

22

65383

13

65954

1

70678

8

70680 X 1.2

2 11/07/14

DART AEROSPACE LTD	Work Order: 71360
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.006	8.000	8.006	8.006		
F	0.490	0.510		.502	.508	.493	.493		
G	0.257	0.262		.259	.257	.257	.257		
H	0.375	0.380		.378	.375	.375	.375		
I	0.490	0.510		.501	.503	.500	.500		
J	1.174	1.184		1.176	1.179	1.179	1.179		
K	0.558	0.578		.568	.565	.565	.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.123	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.254	.252	.252		
S	0.115	0.135		.128	.124	.124	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.960	2.960	2.966		
V	0.230	0.250		.236	.238	.236	.236		
W	0.115	0.135		.123	.124	.124	.124		
X	0.308	0.313		.310	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.368	.364	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.632	.622	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.245	.245	.245		
AE	1.375	1.395		1.385	1.390	1.390	1.390		
AF	0.115	0.135		.136	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.246	.247	.247	.247		
AI	2.000	2.020		2.000	2.004	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>AK/129</i>
Date: 11.7.19

Audited by: <i>B.A.</i>
Date: 11/07/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 71300
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.006	8.006	8.006	8.006		
F	0.490	0.510		.493	.493	.497	.497		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.565	.565	.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.124	.124	.124	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.966	2.966	2.966	2.966		
V	0.230	0.250		.236	.236	.236	.236		
W	0.115	0.135		.124	.124	.124	.124		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.632	.632	.632	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.375	1.395		1.390	1.390	1.390	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.247	.247	.247		
AI	2.000	2.020		2.006	2.006	2.006	2.006		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

RR.02
RR.15
RR.02

Measured by: <u>124</u>
Date: <u>11.7.19</u>

Audited by: <u>BA</u>
Date: <u>11/07/21</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 71300
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.006	8.006	8.006	8.006		
F	0.490	0.510		.497	.497	.497	.497		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.565	.565	.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.124	.124	.124	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.966	2.966	2.966	2.966		
V	0.230	0.250		.236	.236	.236	.236		
W	0.115	0.135		.124	.124	.124	.124		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.632	.632	.632	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.375	1.395		1.392	1.392	1.392	1.392		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.247	.247	.247		
AI	2.000	2.020		2.006	2.006	2.006	2.006		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <u>29</u>
Date: <u>11.7.20</u>

Audited by: <u>B.n</u>
Date: <u>11/07/21</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITH A LATER
WORK ORDER

NO 71360

PH 11-06-29

RELEASED

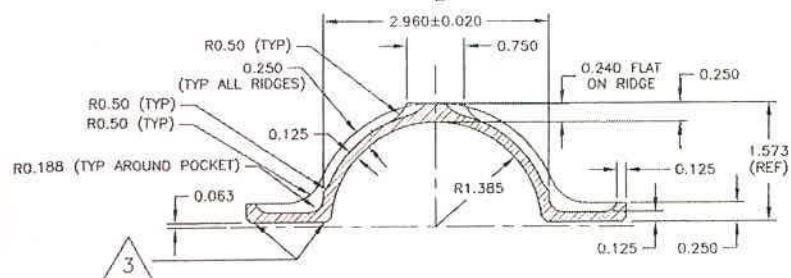
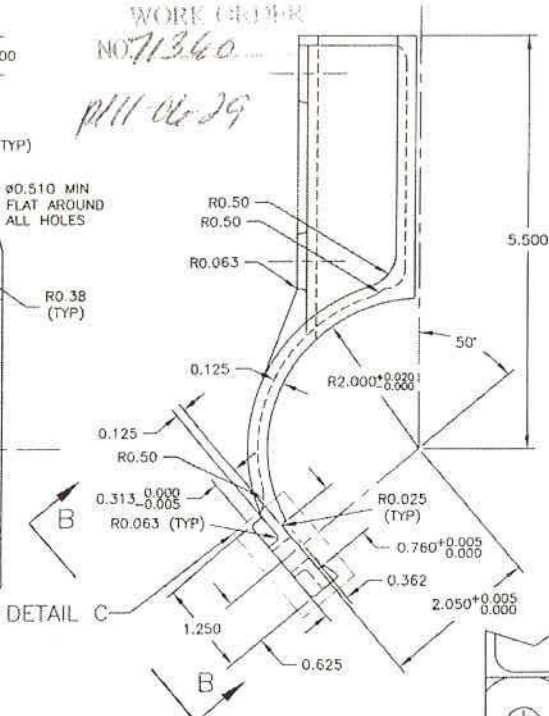
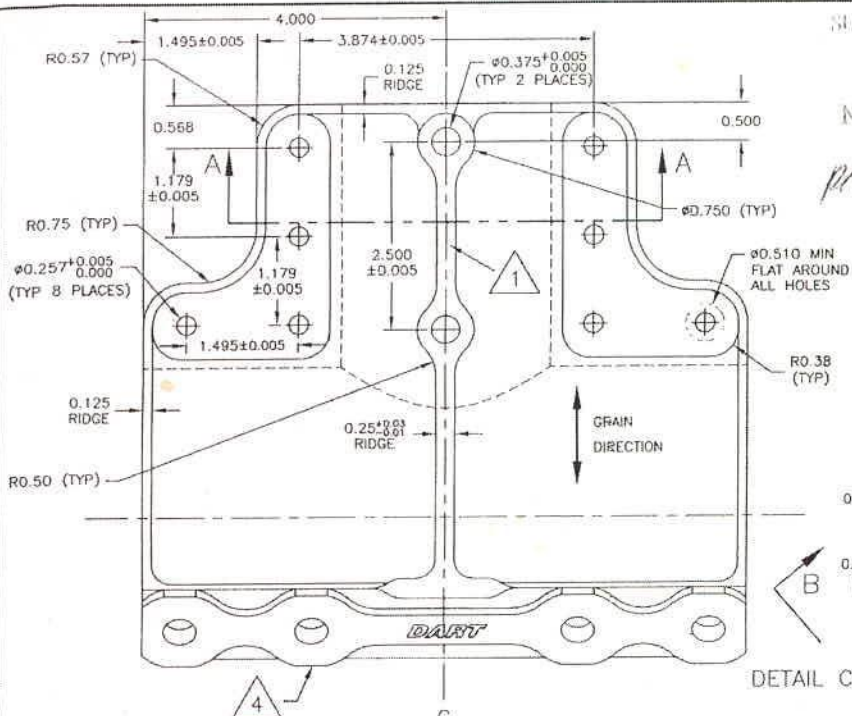
05.12.06

NOTES

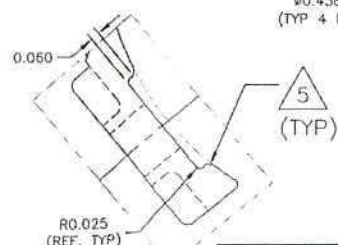
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

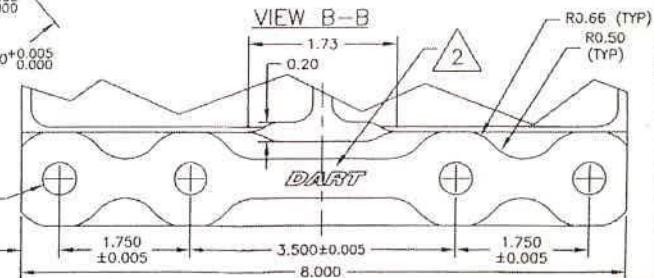
E



SECTION A-A



DETAIL C
SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102
B	96.12.02	ADD DIMENSIONS PER TSR A1177
A	96.09.16	ADD GRAIN DIR., 0.438 WAS 0.425
		NEW ISSUE

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DESIGN	OS	DRAWN BY	PH	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D2571
DATE	05.07.13	TITLE	OUTER FWD SADDLE	REV. E	SHEET 1 OF 1
		SCALE	2:3		